

Date: Thursday, 09/04/2009 8:57:51 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 407 HIGH AFT X-TUBE ASSEMBLY
<b>Job Number</b> : 47100	
<b>Estimate Number</b> : 13208	
<b>P.O. Number</b> :	<b>Part Number</b> : D407667205TRN
<b>This Issue</b> : 09/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D407-667-245 REV F
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : CROSSTUBES	<b>Drawing Revision</b> : F
<b>Previous Run</b> : 47099	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 16/04/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>Julie Dawson</u>	
<b>Comment</b> : Est Rev:A 08-03-06 new issue DD verified by:ec Est Rev B 08.04.02 Removed polish EC verified by: DD Est Rev:C 08-08-19 revE as per dwg DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6011115	Crosstube Material
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number	Description	Batch
1 D6011-115	Crosstube	B 38344

Check OD = 2.750"; ID = 1.450"

A.M 09.04.2009

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8531 on both ends as per Folio FA248

2-Turn first side as per Folio FA248

3- File transition lines smooth.

A.M 09.04.2009

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

A.M 09.04.2009

4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA248

2- File transition lines smooth.

A.M 09.04.2009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 09/04/2009 8:57:51 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 47100

Part Number: D407667205TRN

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D407-667-245

Inside of Cuff(Donot engrave on outside of tube)

*a.m 09.09.2008*

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*a.m 09.04.2008*

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*5 09/04/22*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Ensure no sand is in the tube before alodine.

*ARM 9-4-23* *(1)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*a.m 09.04.230*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock in kanban rack

Location: *X-TUBE CELL*

*ARM 9-4-23* *(1)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/04/23* *(1)*

Job Completion



*u 09.04.23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47100
<b>Description:</b> Crosstube Assembly		<b>Part Number:</b> D407-667-245
<b>Inspection Dwg:</b> D407-667-245 <b>Rev:</b> 01		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.495	/			
	1.832	+0.005/-0.000	1.837	/			
	1.838	+0.005/-0.000	1.843	/			
	1.892	+0.005/-0.000	1.897	/			
	2.052	+0.005/-0.000	2.057	/			
	2.206	+0.005/-0.000	2.211	/			
	2.521	+0.005/-0.000	2.525	/			
	2.633	+0.005/-0.000	2.636	/			
	4.10	+/-0.030	4.10	/			
	4.978	+/-0.030	4.986	/			
	2.040	+0.000/-0.010	2.035	/	2.035		
	0.125	+/-0.010	0.125	/			
	R0.063	+/-0.010	R0.063	/			
	R0.500	+/-0.010	R0.500	/			
SIDE B	2.490	+0.005/-0.000	2.490	/			
	1.832	+0.005/-0.000	1.835	/			
	1.838	+0.005/-0.000	1.843	/			
	1.892	+0.005/-0.000	1.897	/			
	2.052	+0.005/-0.000	2.057	/			
	2.206	+0.005/-0.000	2.208	/			
	2.521	+0.005/-0.000	2.525	/			
	2.633	+0.005/-0.000	2.636	/			
	4.10	+/-0.030	4.130	/			
	4.978	+/-0.030	4.978	/			
	2.040	+0.000/-0.010	2.040	/			
	0.125	+/-0.010	0.115	/			
	R0.063	+/-0.010	R0.063	/			
	R0.500	+/-0.010	R0.500	/			
	112.91	+/-0.020	112.910	/			

<b>Measured by:</b> a.m	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09.04.22	<b>Date:</b> 09/04/22	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-205)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	06.03.30	Tolerance revised for 4.978 dimension	KJ/JLM	
D	07.02.19	Dwg Rev updated	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Item	QTY -245	PART NUMBER	DESCRIPTION
1	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	1	D6011-115	CROSSTUBE
3	2	D2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2873-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6011-115  
FINISHED LENGTH = 112.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON  
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 27.7 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND  
6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO  
PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1  
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE  
SUPPORT.  
NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS.  
ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF  
CROSSTUBE, PER QSI 035.
- 16) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE  
OPPOSITE D2894-1 SUPPORT.
- 17) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

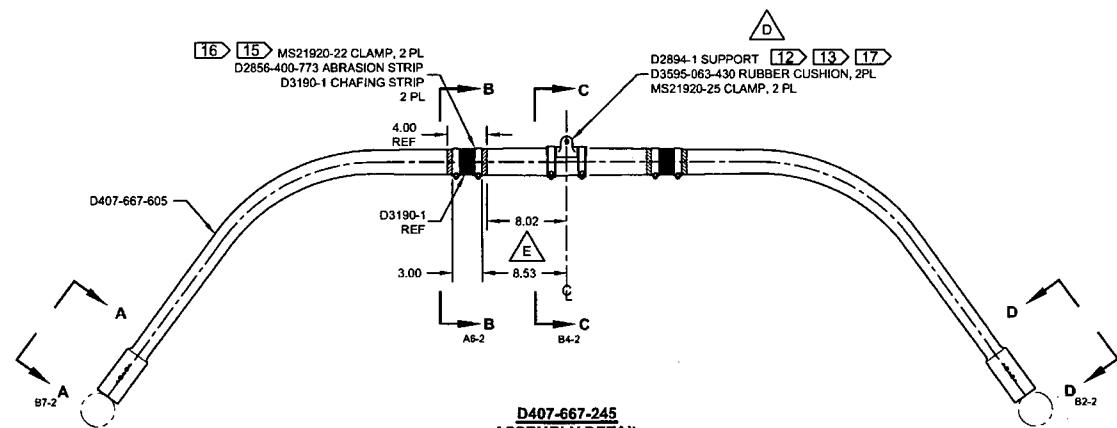
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01/11/12 N/A

F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECN#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D407-667-245	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASSY (407 HIGH AFT)	NTS
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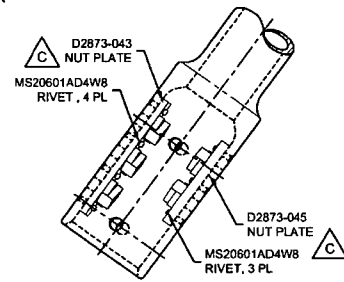
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16 15 MS21920-22 CLAMP, 2 PL  
 D2856-400-773 ABRASION STRIP  
 D3190-1 CHAFING STRIP  
 2 PL

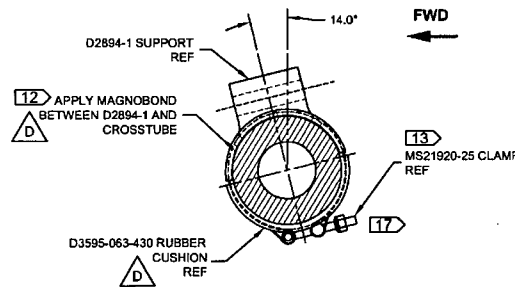
D2894-1 SUPPORT 12 13 17  
 D3595-063-430 RUBBER CUSHION, 2PL  
 MS21920-25 CLAMP, 2 PL



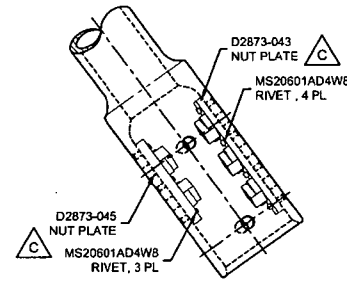
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**ASSEMBLY DETAIL**  
 (VIEW LOOKING FWD)



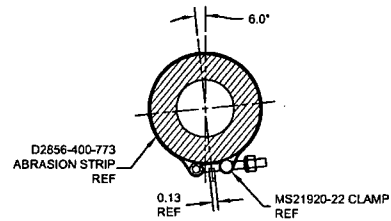
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 SCALE 4X



**SECTION C-C**  
 SCALE 4X



**VIEW D-D CUFF DETAIL**  
 SCALE 4X



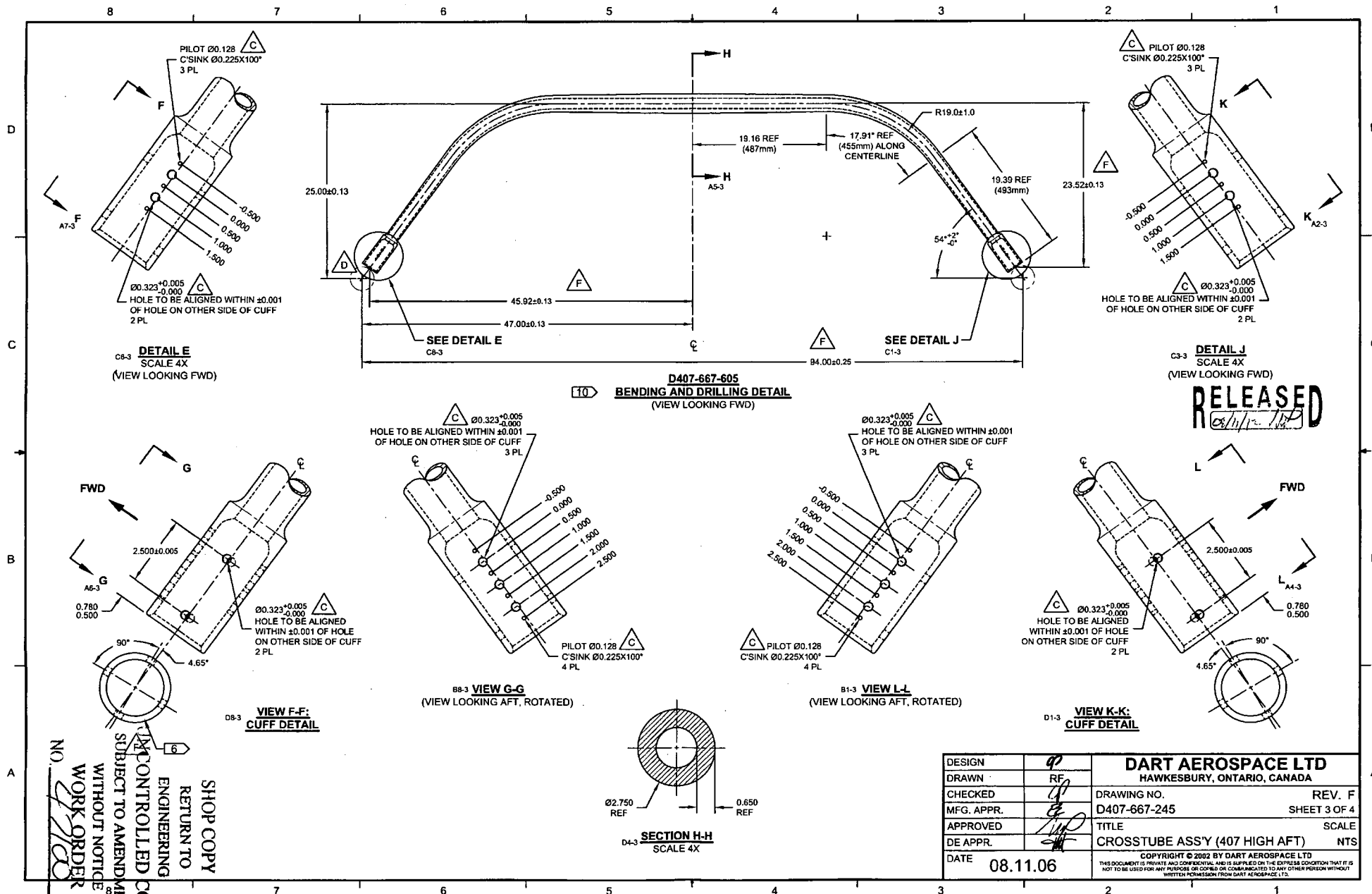
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**RELEASED**

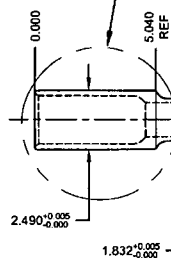
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CHECKED	9	DRAWING NO.	REV. F
MFG. APPR.	9	D407-667-245	SHEET 2 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
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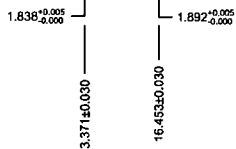




SEE DETAIL M  
A7-4

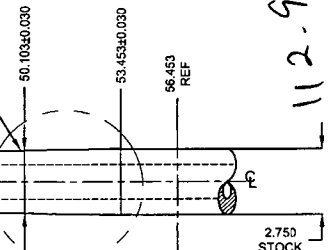


R100.0 TRANSITION  
BETWEEN TAPERED  
SECTIONS



R100.0 TRANSITION  
BETWEEN TAPERED  
SECTIONS

R100.0 TRANSITION  
BETWEEN TAPERED  
SECTIONS

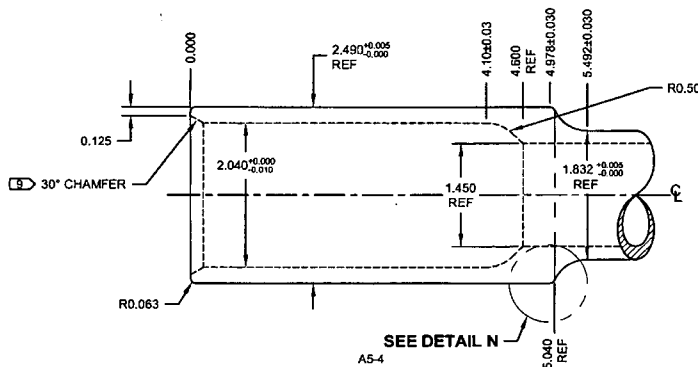


SEE DETAIL P  
A2-4

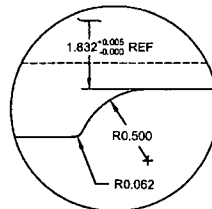
TAPER UNIFORMLY FROM  
2.633 +0.005/-0.000 REF THROUGH TO 2.790 +0.005/-0.000 REF  
RUNNING OFF PART

RELEASED  
08/11/12 JHT

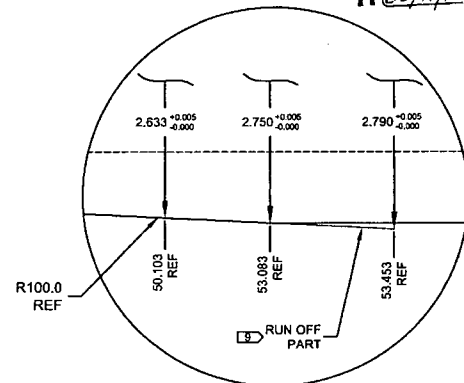
**D407-667-245 MACHINING DETAIL**



SEE DETAIL N  
A5-4



**DETAIL N: CUFF TRANSITION**  
SCALE 2X



**DETAIL P: TAPER RUN-OFF**  
NOT TO SCALE

**DETAIL M: CROSSTUBE CUFF**  
SCALE 3X

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